

*Push Split*  
Work Order ID 96174

January-23-13 12:47:20 PM

\*96174\*

Page 1

Item ID: D3703-1

Revision ID:

Item Name: Aft Doubler

Start Date: 1/23/13

Start Qty: 4.00

Required Date: 2/06/13

Req'd Qty: 4.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: *ML5*

Date: 13-01-24 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3703

B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3703

6061-003

Dwg Rev: *B*

Prog Rev: *2*

\*\*\*\*grain direction along 6.30\*\*\*\*

2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control



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Item ID: D3703-1

Revision ID:

Item Name: Aft Doubler

Start Date: 1/23/13 Start Qty: 4.00

Required Date: 2/06/13 Req'd Qty: 4.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

6

130201

DAS  
09  
9-89

130

Bend as per dwg  
NC BRAKE

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

3

8/13/09/17

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

DAS  
27  
9-89  
139.4

3





# Work Order ID 96174

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Page 3

Item ID: D3703-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Doubler

Start Date: 1/23/13 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 2/06/13 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

3 1613.95

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

139.5

3

170

Identify as per dwg & Stock Location: 5T256

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

(1x)PPP 106472

3x

13-09-5



**Work Order ID 96174**

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**\*96174\***

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Item ID: D3703-1

Revision ID:

Item Name: Aft Doubler

Start Date: 1/23/13 Start Qty: 4.00

Required Date: 2/06/13 Req'd Qty: 4.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

13/9/9

mf  
13-9-6





# Picklist Print

January-23-13 12:47:20 PM

Page 1

Work Order ID: 96174  
 Parent Item: D3703-1  
 Parent Item Name: Aft Doubler

Start Date: 1/23/13 Required Date: 2/06/13  
 Start Qty: 4.00 Required Qty: 4.00

Comments: IPP Rev:A 08-04-24 new issue DD verified by:EC IPP REV:B 13.01.15 AS PER  
 DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No				sf	323.0625		3.0315788			

1-23-13 3.00 13.01.15

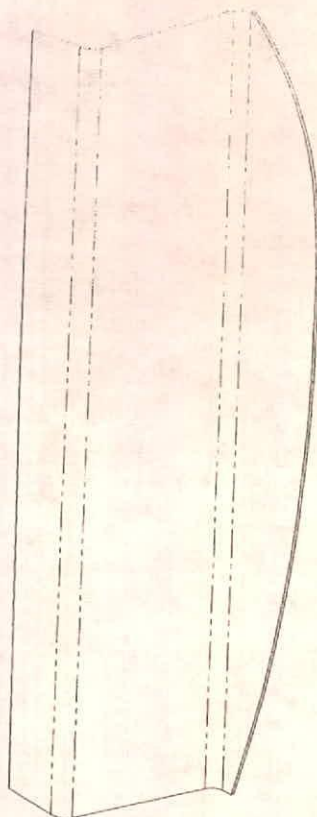
Location	Loc Qty	Loc Code
MAT021	323.0625	
123135	124.4625	
124003	198.6	



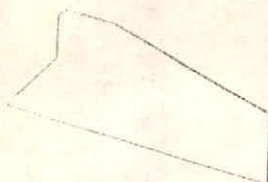




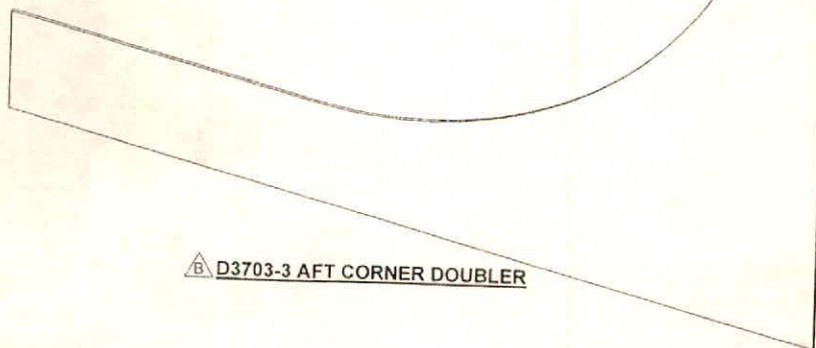




8 D3703-1 AFT DOUBLER



B D3703-5 AFT CAP



B D3703-3 AFT CORNER DOUBLER

96174 NLS  
13-01-24

RELEASED  
2013-01-14

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S 063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
- 7) WEIGHT: D3703-1 = 0.56 lbs, D3703-3 = 0.23 lbs, D3703-5 = 0.03 lbs
- 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

B	REVISED D3703-3/-5, REASON: FAR12-18B/CIR12-4	MB	12.12.06
A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.12.06		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D3703

REV. B

SHEET 1 OF 4

TITLE  
AFT DOUBLER

SCALE

NTS

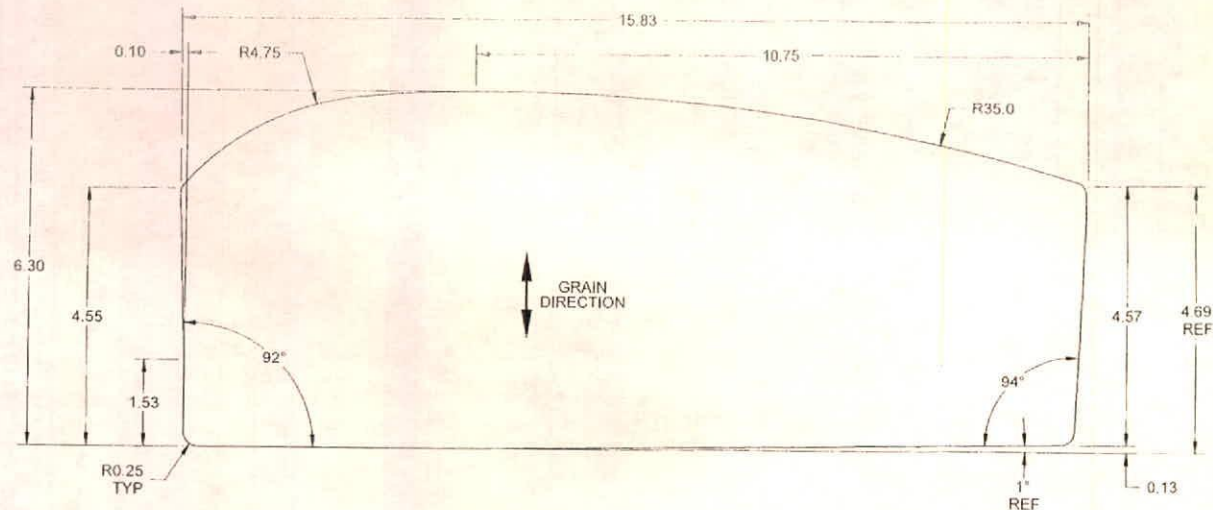
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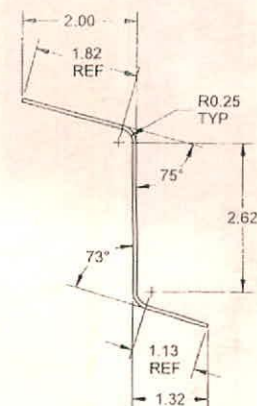




96174



**D3703-1F AFT DOUBLER FLAT PATTERN**



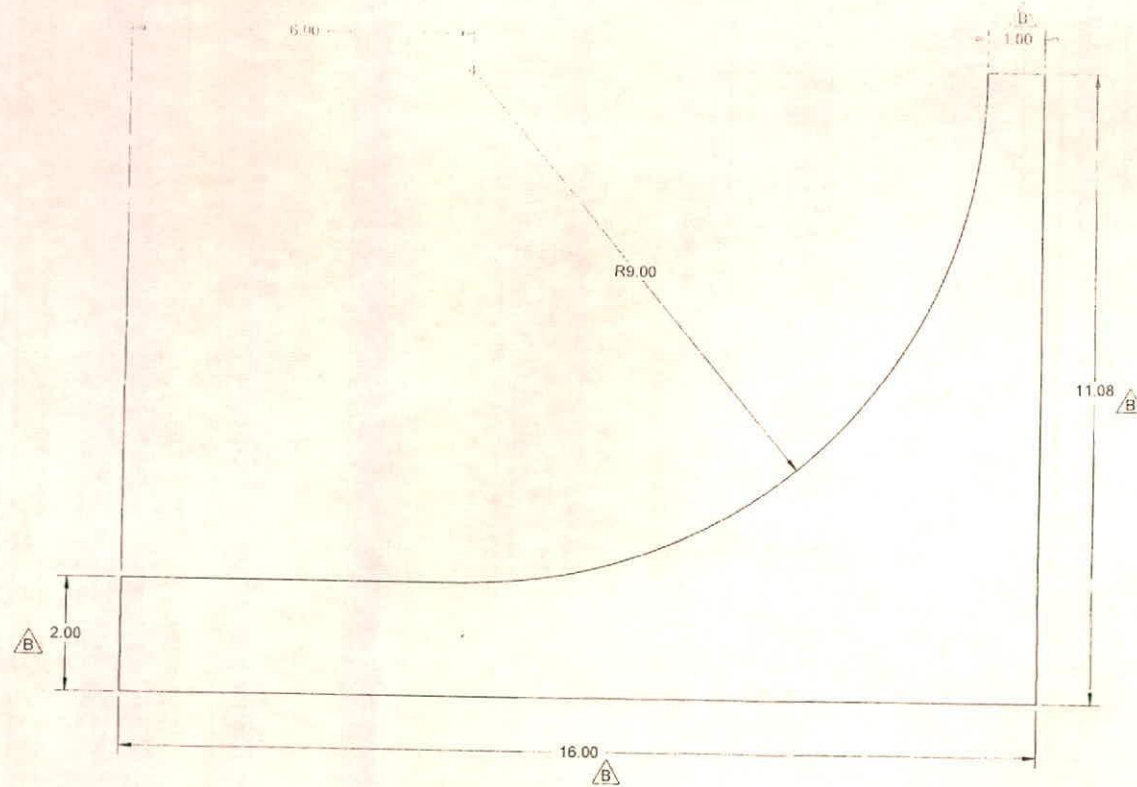
**D3703-1 AFT DOUBLER  
(MAKE FROM D3703-1F)**

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**D3703-3 AFT CORNER DOUBLER**

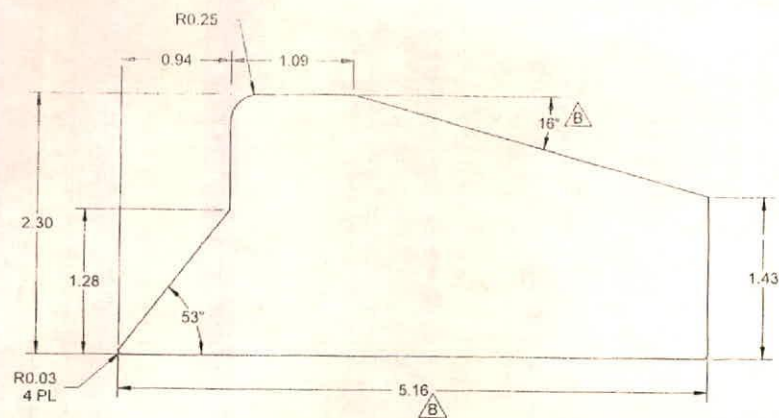
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2013-01-14

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90174



D3703-5 AFT CAP

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2013-01-14

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